

D3440-13

Work Order ID 111122

Thursday, January 09, 2014 11:30:44 AM

B111122

111122

D3440-13

Accept

N900040100

BFK

Page 1

Item ID: D3440-13

Revision ID: B111122

Item Name: Bracket (Supersedes B67-43001-273)

Start Date: 1/9/2014 Start Qty: 10.00 *10*

Required Date: 1/24/2014 Req'd Qty: 10.00 *10*

Reference:

| | | | | | | | |
|------------|-------------------------|-----------------------|------------|-------|------|-------|-------|
| Approvals: | Process Plan: <u>Mf</u> | Date: <u>14-01-09</u> | Tooling: | Date: | Run | Start | *NR1* |
| QC: | | Date: | SPC (Y/N): | Date: | Stop | | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3440 | Rev A | | | | | | | | |

100 0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank: 2.00" x 2.00" x 2.200" long

on 14/01/15

10 0

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA539 and Dwg D3440Dwg Rev: A Identify as
D3440-13Folio Rev: A Deburr

FK 14/01/20

10 0

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

FK 14/01/20

10 0

MISS
2380-12

Work Order ID 111122***111122***

Page 2

Thursday, January 09, 2014 11:30:44 AM

Item ID: D3440-13

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bracket (Supersedes B67-43001-273)

Stop

NS2

Start Date: 1/9/2014 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 10.00

10

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 130 *130* QC | QC8- Inspect parts - second check | 0.00 | | | | | | | DAS 40 9-89 |

Quality Control

14/01/21

140

Identify as per dwg & Stock Location: Set Meter 2. 0.00***140***

Packaging

Packaging

10X 14-1-21

DAS
26
9-89

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Quality Control

MLJ 14-01-21

MLJ 14-01-21

Picklist Print

Thursday, January 09, 2014 11:30:43 AM

Page 1

Work Order ID: 111122

Parent Item: D3440-13

Parent Item Name: Bracket (Supersedes B67-43001-273)

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 10.00

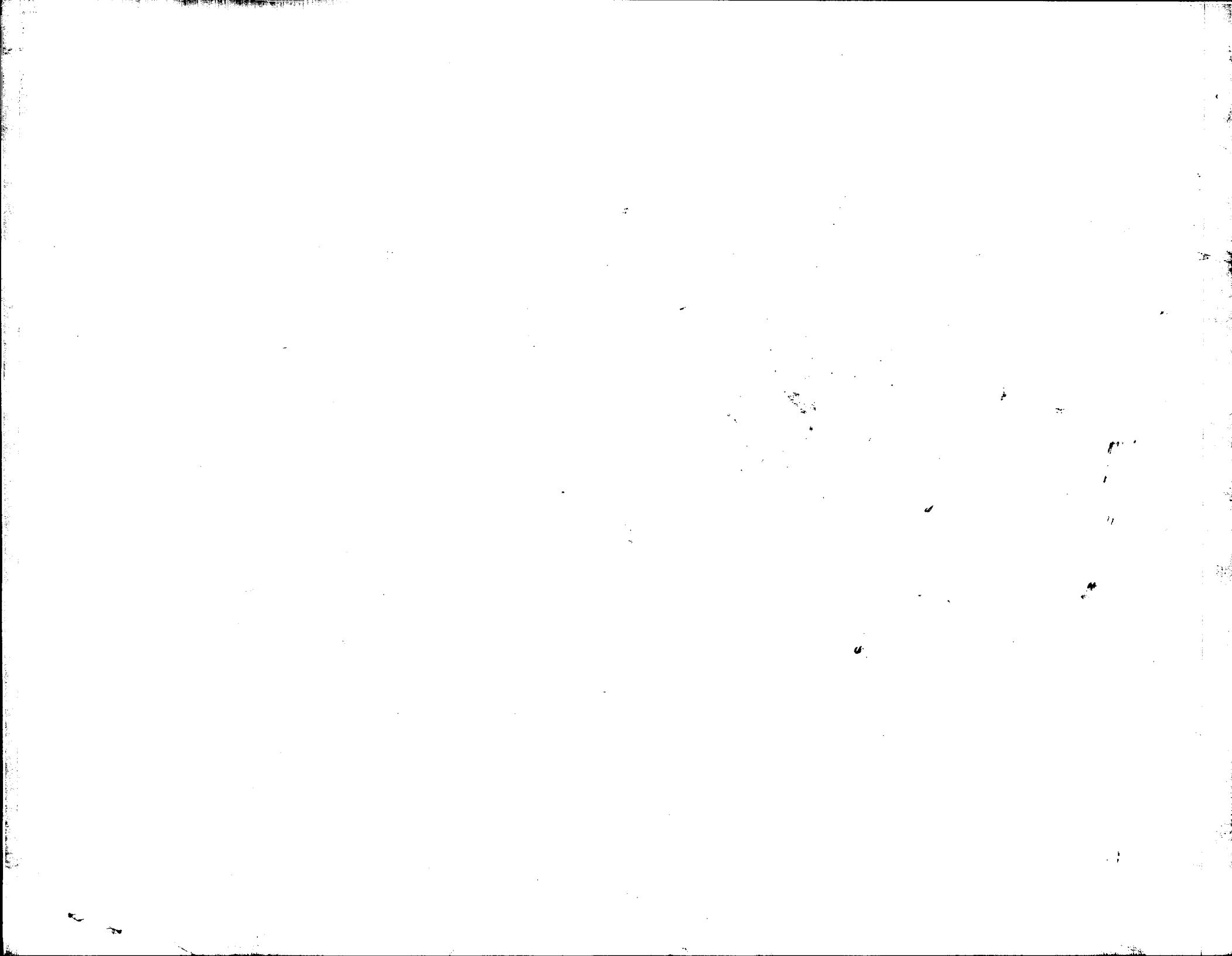
Required Qty: 10.00

Comments: IPP A05.07.13New issueKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B2.000X02.000 6061-T6 Bar 2.00 x 2.00 | | Purchased | No | | | 100 | f | 14.1250 | 0.1833 | 2 | | | |

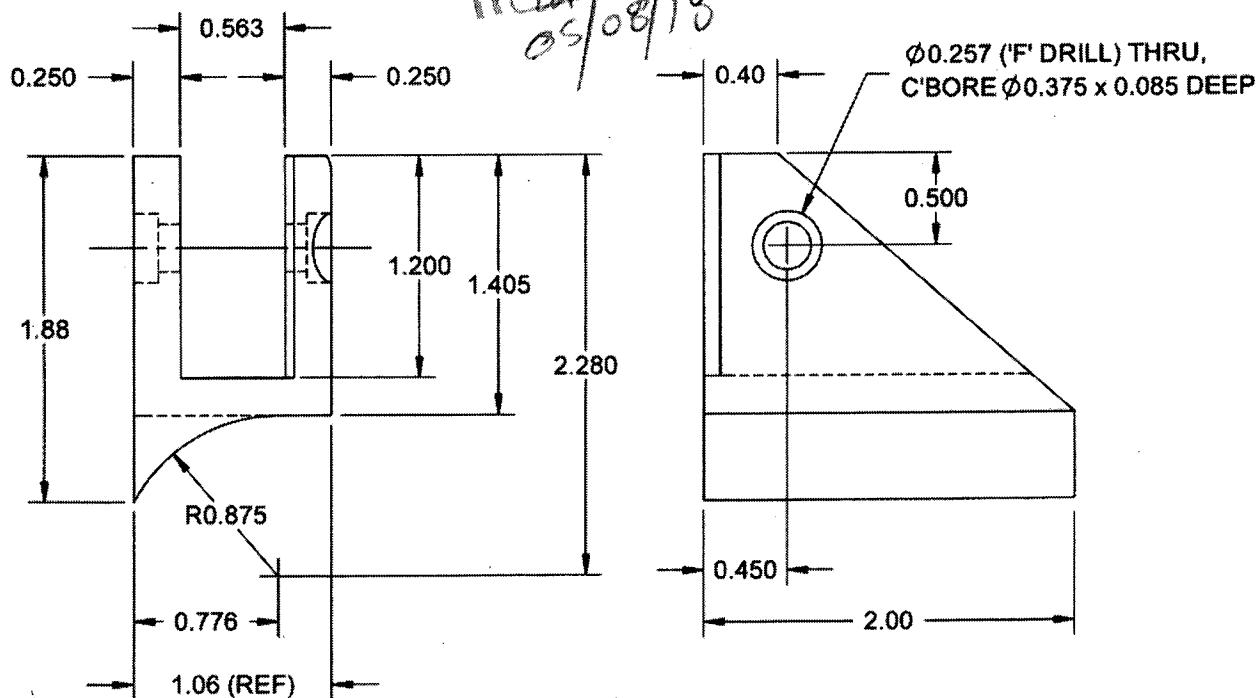
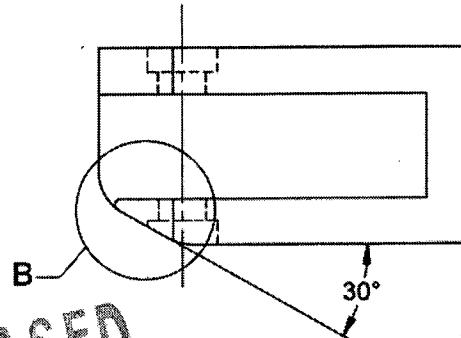
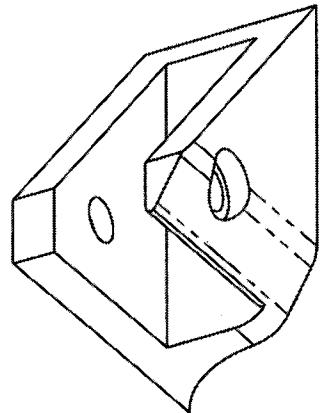
| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT009 | 14.125 | |
| 124443 | 14.125 | |

2.00 on 14/01/15





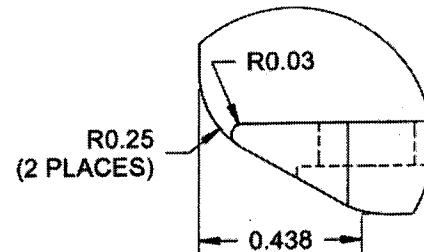
| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3440 | REV. A SHEET 6 OF 7 |
| DATE 05.06.02 | TITLE BLADE FOLD KIT PARTS | SCALE 1:1 | |



D3440-13 BRACKET SUPERSEDES PREMIER P/N B67-43001-273

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DETAIL B
SCALE 2 : 1

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date: _____

Work Order update only

| | | | | | | | |
|-------------------|--|--|--|--|--|--|--|
| Work Order: _____ | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. _____ | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | |
| NCR No. _____ | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | | |
|--------------|--|---------|---|--|---|--|
| Landing Gear | Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube | General | Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function | Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence | Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge | Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other |
| | | | | | | |

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 111122 |
| Description: Bracket | Part Number: | D3440-13 |
| Inspection Dwg: D3440 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

15

| | | | | | |
|--------------|----------|-------------|------------|---------------------|-----|
| Measured by: | F.K. | Audited by: | 40 S-89 | Prototype Approval: | N/A |
| Date: | 14/01/20 | Date: | 14/01/21 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---------------|-------------------|---|
| A | 08.09.04 | New Issue | KJ/DD |  |

